

Date: Monday, 1/23/2006 7:52:05 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (19"X24")
Job Number : 25584	
Estimate Number : 10323	
P.O. Number : N/A	Part Number : K10008
This Issue : 1/23/2006 S.O. No. : N/A	Drawing Number : D2432 REV F3
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : F3
Previous Run : 25367	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/27/2006
Checked & Approved By : SEE COMMENT BELOW	Qty: 20 Um: Each
Comment : Est Rev:J 04.02.17 Blank size changed KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile:

K10008

D206-559-013

D350-578-011

D315-670-011

D427-659-011

and create labels per PPP K10008

CHG006(Bag Bluefiles separately)

DH: 06/01/27

2.0

MUHMB10

UHMW 1" Black

**Comment:** Qty.: 6.8250 sf(s)/Unit Total : 136.5000 sf(s)

blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5

Material: Black UHMW 1"

(MUHMB10)

Batch: M19541

J.L 06.01.23

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1

**Comment:** HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

SA/J.L 06.01.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/23/2006 7:52:05 AM
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Part Number: K10008

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD/J.L 06.01.23 20

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

BK 06.01.25 20

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

7.0	D2182B	Neoprene Cushion-.750 bl
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Comment: Qty.: 0.4166 f(s)/Unit Total: 8.3320 f(s)
Pick: Packing Kit
Qty Part Number Description Batch
6 D2182B050 Rubber Cushion B23172

8.0	D2274	Radius Block
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 240.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
12 D2274 Radius Block B25223
2 D2432F(ref only) Bearpaw B25584

9.0	D2438	Clamp
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 120.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
6 D2438 Clamp B25015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: K10008

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer B25372

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4166 Each(s)/Unit Total : 8.3320 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion B24182

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt M19085

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M15432

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 480.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M18431

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4) M17997

06/1/26 (10)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06/01/27 (10)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10008

Location: _____

REV. E

06/01/27 (10)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/01/30 10

SP 06/01/30¹⁰

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 06/01/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25584
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.055	✓			
B	5.500	+/-0.030	5.499	✓			
C	0.200	+/-0.030	.195	✓			
D	0.25 x 45°	+/-0.030	.230	✓			
E	R0.250	+/-0.030	.250	✓			
F	0.250	+/-0.010	.252	✓			
G	0.625	+/-0.030	.623	✓			
H	0.375	+/-0.010	.377	✓			
I	0.950	+0.030/0.010	.950	✓			
J	19.000	+/-0.030	19.000	✓			m-tapl
K	3.14	+/-0.030	3.145	✓			
L	3.28	+/-0.030	3.278	✓			
M	Ø0.260	+0.005/-0.000	.260	✓			
N	Ø0.93	+/-0.030	.931	✓			
O	0.30	+0.030/-0.000	.300	✓			
P	23.750	+/-0.030	23.750	✓			
Q	7.375	+/-0.030	7.378	✓			
R	4.250	+/-0.010	4.252	✓			
S	2.000	+/-0.030	2.005	✓			
T	9.000	+/-0.010	9.008	✓			
U	9.000	+/-0.010	9.008	✓			
V	0.375	+/-0.010	.377	✓			

Measured by:	SL	Audited by:	En	Prototype Approval:	N/A
Date:	06-01-23	Date:	06/01/23	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

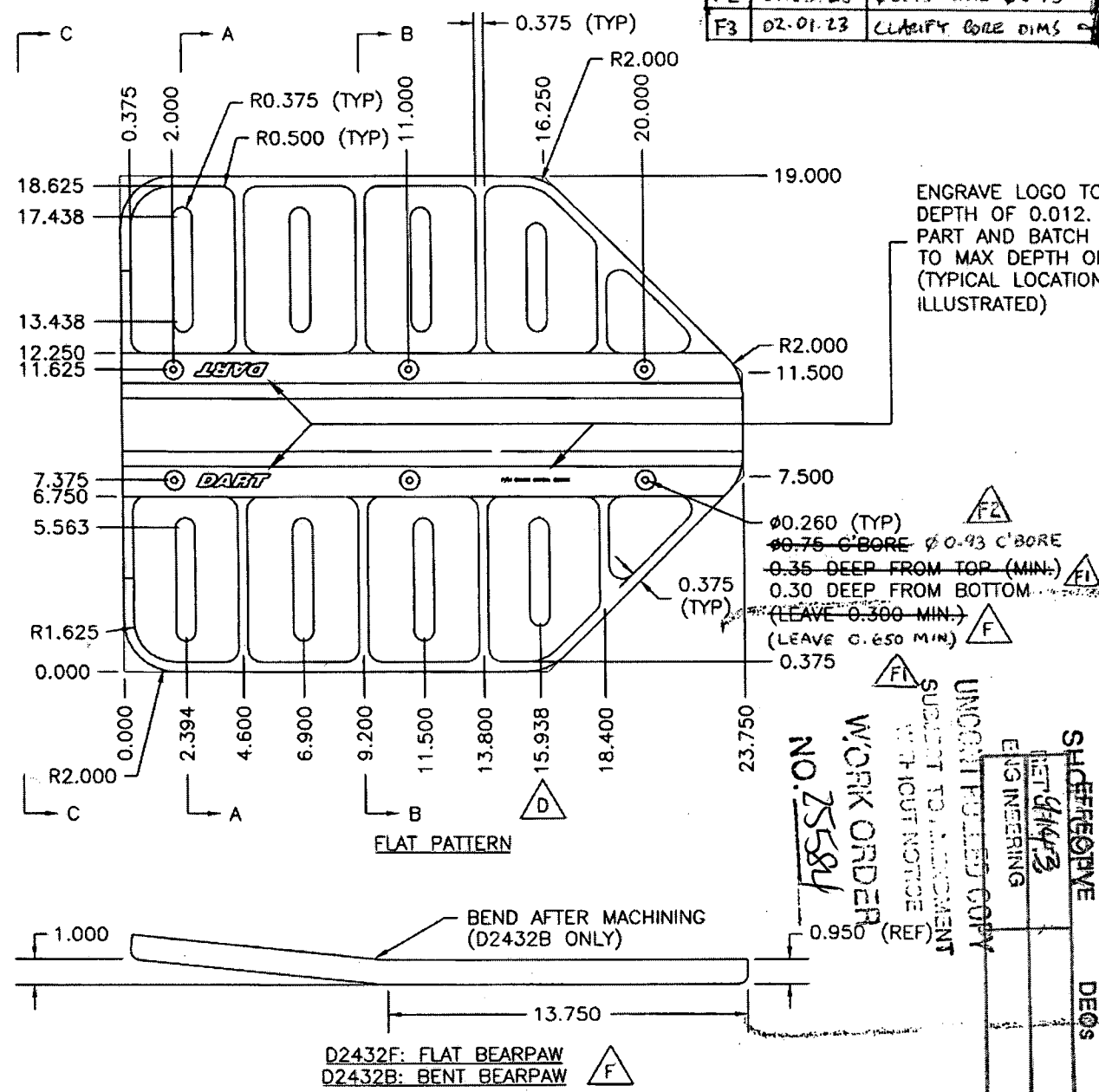


RELEASED
98.06.17 KE

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
KE	KE	DRAWING NO.	REV. F
CHECKED MM	APPROVED JS	D2432	SHEET 1 OF 2
DATE 98.05.12	TITLE BEARPAW	SCALE 1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SHEET 2 OF 2
WORK ORDER

NO. 25584

